

Work Order ID 61938

Monday, September 13, 2010 8:17:02 AM

Page 1

Item ID: D4172-1

Accept

Revision ID: PRELIM

Item Name: Supporting Plate

Start Date: 9/10/2010 Start Qty: 3.00

Required Date: 9/17/2010 Req'd Qty: 3.00

Reference:

Approvals:

Process Plan:

Date: 10-9-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4172

PA1

100

0.00

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: PA1

Prog Rev: PA1

2-Deburr if necessary

0.00

10-9-13

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

10-9-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 61938

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Page 3

Item ID: D4172-1 Accept

Revision ID: PRELIM

Item Name: Supporting Plate

Start Date: 9/10/2010 Start Qty: 3.00

Required Date: 9/17/2010 Req'd Qty: 3.00

Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location: Warehouse

0.00

Memo

0.00

AT 10-09-23 (x2)
~~21 10-09-23~~

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/29

1009-23

POSITIVE RECALL

EFFECTIVE

10.09.13

AUTH

u

RELEASED

DATE

10.09.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 13, 2010 8:17:07 AM

Page 1

Work Order ID: 61938



Parent Item: D4172-1



Parent Item Name: Supporting Plate

Start Date: 9/10/2010

Required Date: 9/17/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	125.2600	1.5645	4.940526			



6061-T6 .125 Sheet



1B10-9-13

Location

Loc Qty

Loc Code

MAT21

125.26

113608

96

114352

29.26

113608

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 61938
Description: SUPPORTING PLATE		Part Number: D4172-1
Inspection Dwg: D4172-1 Rev: PM1		Page 1 of 1

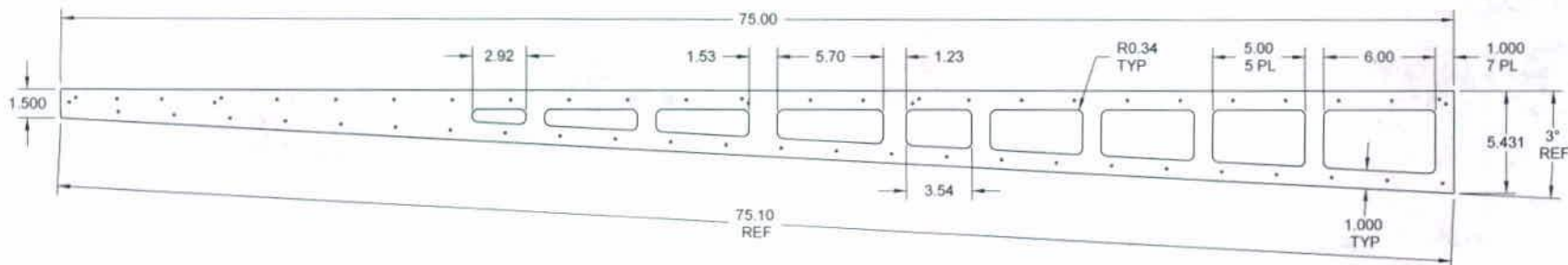
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

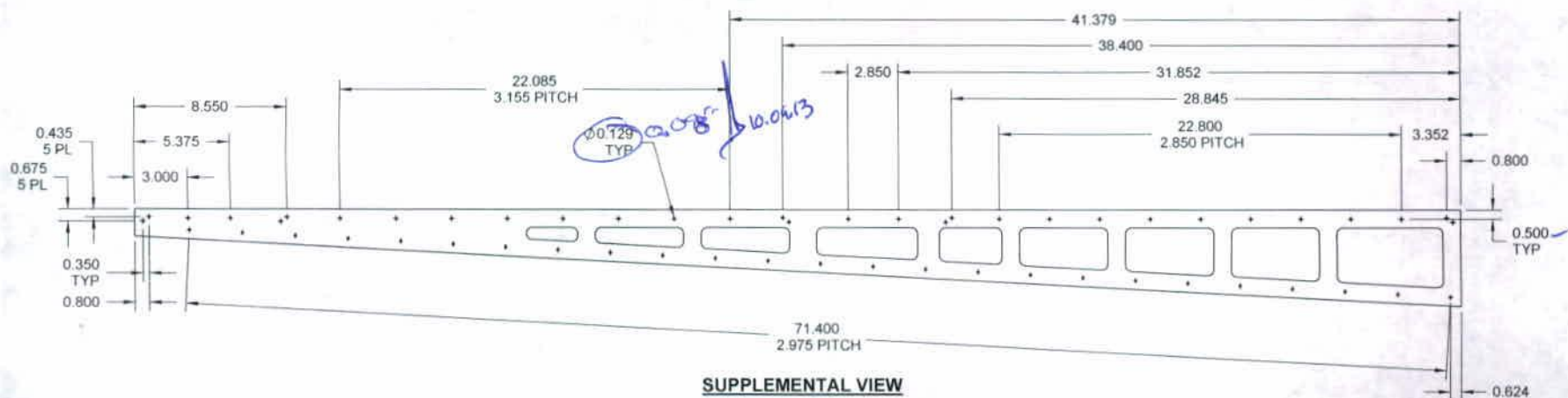
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.29	+0.005 -0.001	1.29	✓		V 1862	
1.500	+/- .010	1.498	✓		V	
2.92	+/- .030	2.920	✓		V	
1.53	+/- .030	1.533	✓		V	
5.70	+/- .030	5.702	✓		V	
1.23	+/- .030	1.228	✓		V	
3.54	+/- .030	3.541	✓		V	
5.00	+/- .030	4.997	✓		V	
6.06	+/- .030	5.999	✓		V	
1.000	+/- .010	1.003	✓		V	
5.431	+/- .010	5.436	✓		V	
1.000	+/- .010	1.006	✓		V	
75.16	+/- .030	75.10	✓	✓	T 1801	
.435	+/- .010	.435	✓		V	
.675	+/- .010	.672	✓		V	
.350	+/- .010	.356	✓		V	
.800	+/- .010	.796	✓		V	
3.000	+/- .010	3.003	✓		V	
5.375	+/- .010	5.380	✓		V	
8.550	+/- .010	8.546	✓		V	
22.085	+/- .010	22.085	✓		V	
3.155	+/- .010	3.157	✓		V	

Measured by: RB	Audited by: S	Prototype Approval: N/A
Date: 10-9-13	Date: 10/09/13	Date: N/A
Inspector: to Pat Dwyer		
Rev	Date	Change
A		New Issue
Revised by: KJ/JLM		Approved

more →



D4172-1 SUPPORTING PLATE



SUPPLEMENTAL VIEW

PRELIMINARY ISSUE
10.09.08

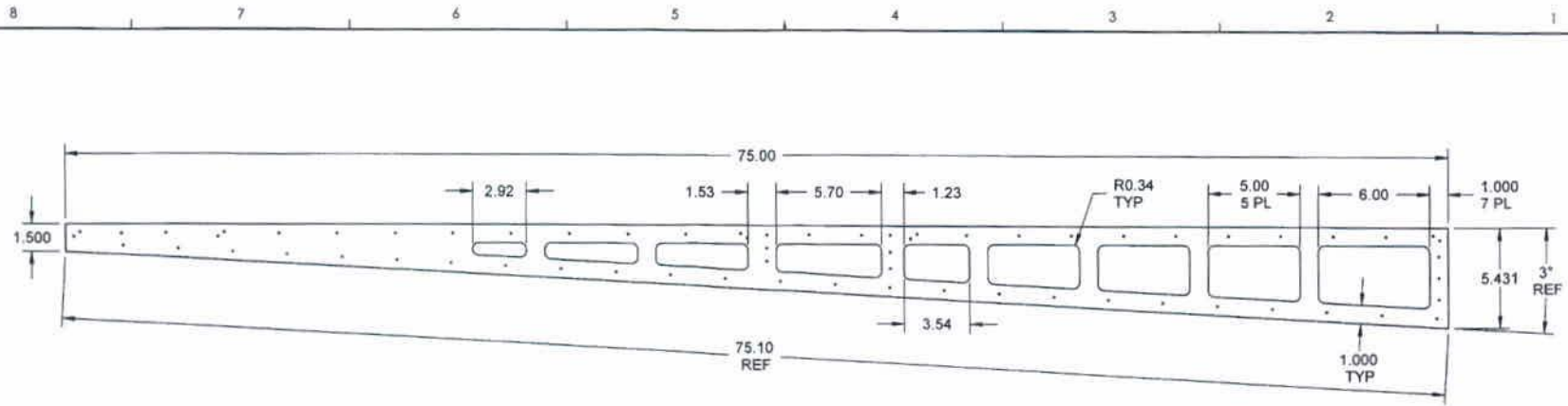
NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.78 lbs

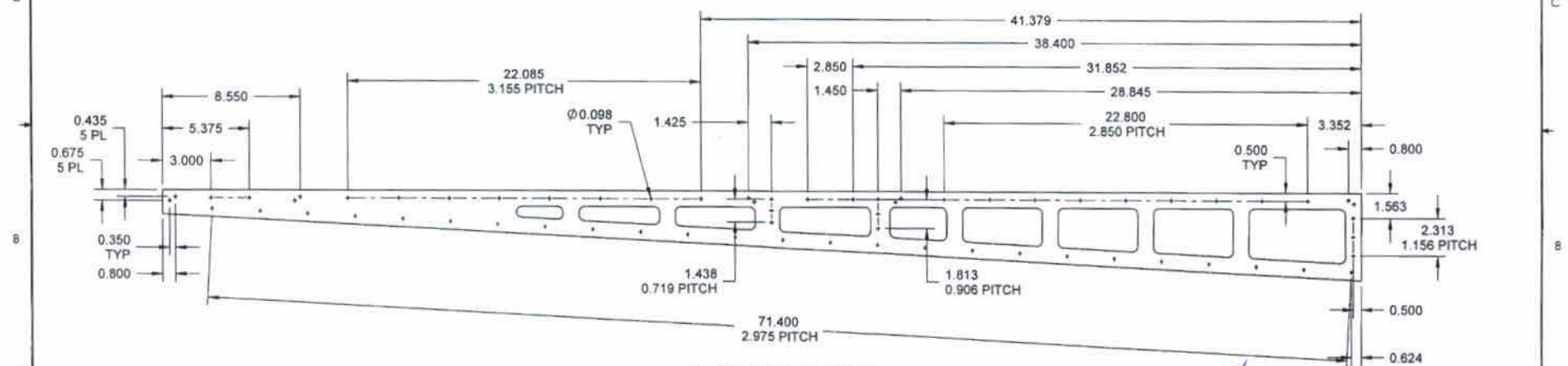
STANDARD
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WORK ORDER
NO. **4193E**

BS10-9-B

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA
MFG APPR		D4172	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR		POD MOUNTING FRAME ASSY	NTS
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D4172-1 SUPPORTING PLATE



SUPPLEMENTAL VIEW

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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.78 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4172	SHEET 5 OF 7
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RELEASED
2010-09-29

61938